

# Work Order ID 54022

November 26, 2009 7:50:25 AM



Page 1

Item ID: D407-559-113

Accept



Setup Start



Revision ID:

Item Name: Bearpaw, Large

Stop



Start Date: 11/26/2009 Start Qty: 3.00



Cust Item ID:

Required Date: 11/27/2009 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: *mf*

Date: *09-11-26* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN-D206-559

K

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPPD407-559-113 CHG001

*507/11/26*

*100 for BG 09/11/26*

160

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

*160 9/14/26 (3)*

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

*170 09/14/26*

*170*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 54022**

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Item ID: D407-559-113

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw, Large

Start Date: 11/26/2009 Start Qty: 3.00



Cust Item ID:

Required Date: 11/27/2009 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD407-559-113  
Location: \_\_\_\_\_

\_\_\_\_\_ 09/11/26 (2)

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

\_\_\_\_\_ 09/11/26

MF  
09-11-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

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Work Order ID: 54022

Parent Item: D407-559-113

Parent Item Name: Bearpaw, Large

Comments: IPP RevA: New issue DD 09.10.29 verified by:EC  
IPP RevB: ECN09-698p DD 09.11.03 verified by:EC  
as per revision K DD 09.11.24 verified by:EC

IPP RevC:

Start Date: 11/26/2009

Required Date: 11/27/2009

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2274RevF		Manufactured	No			160	Each	363.0000	60.0000			
Radius Block												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 363

22494 0

23174 0

52644 363

D3456-1RevA 28 Manufactured No

160

Each

138.0000

6.0000

Washer

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG 7

25701 7

Main Warehouse

ST 131

51653 131

D4010-041 Manufactured No

160

Each

0.0000

6.0000

Bearpaw Assembly

B53815 +6

SAD

09-11-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Comments: IPP RevA: New issue DD 09.10.29 verified by:EC  
IPP RevB: ECN09-698p DD 09.11.03 verified by:EC  
as per revision K DD 09.11.24 verified by:EC









IPP RevC:

Start Date: 11/26/2009

Required Date: 11/27/2009

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ D4011-1	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 160	Unit of Each	Qty on 66.0000	Remaining 24.0000	Qty	Date	Status
												
Clamp, Short												
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>53832</div>												
D4011-3		Manufactured	No			160	Each	33.0000	6.0000			
												
Clamp, Long												
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>53833</div>												
D4011-5		Manufactured	No			160	Each	0.0000	24.0000			
												
Clamp-Short												
D4012-1		Manufactured	No			160	Each	25.0000	30.0000			
												
Cushion												
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>53835</div>												

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 54022



Parent Item: D407-559-113



Parent Item Name: Bearpaw, Large

Start Date: 11/26/2009

Required Date: 11/27/2009

Comments: IPP RevA: New issue DD 09.10.29 verified by:EC  
IPP RevB: ECN09-698p DD 09.11.03 verified by:EC  
as per revision K DD 09.11.24 verified by:EC

IPP RevC:

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN4C10A 2P 		Purchased	No			160	Each	134.0000	6.0000			
Bolt												

*EC*

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	134
101189	5
106302	29
111295	50
112243	50

106302

AN4C13A 4X

Purchased No

160 Each 87.0000 12.0000



*EC 9/11/2009 (3)*

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	87
105289	3
106785	12
108084	50
110159	22

1108084

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 54022

Parent Item: D407-559-113

Parent Item Name: Bearpaw, Large

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IPP RevB: ECN09-698p DD 09.11.03 verified by:EC  
as per revision K DD 09.11.24 verified by:EC



IPP RevC:

Start Date: 11/26/2009

Required Date: 11/27/2009

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status																		
6 AN4C15A FP  B Bolt		Purchased	No			160	Each	83.0000	24.0000																					
<table><tr><th>Warehouse</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>Location</td><td></td><td></td></tr><tr><td>Main Warehouse</td><td></td><td></td></tr><tr><td>ST</td><td>83</td><td></td></tr><tr><td>103915</td><td>1</td><td></td></tr><tr><td>111819</td><td>82</td><td></td></tr></table>													Warehouse	Loc Qty	Loc Code	Location			Main Warehouse			ST	83		103915	1		111819	82	
Warehouse	Loc Qty	Loc Code																												
Location																														
Main Warehouse																														
ST	83																													
103915	1																													
111819	82																													
S AN4C17A FP  B BOLT	Purchased		No			160	Each	84.0000	24.0000		11/11/19 113228	6/9/4/26 (3)																		
<table><tr><th>Warehouse</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>Location</td><td></td><td></td></tr><tr><td>Main Warehouse</td><td></td><td></td></tr><tr><td>ST</td><td>84</td><td></td></tr><tr><td>113228</td><td>84</td><td></td></tr></table>													Warehouse	Loc Qty	Loc Code	Location			Main Warehouse			ST	84		113228	84				
Warehouse	Loc Qty	Loc Code																												
Location																														
Main Warehouse																														
ST	84																													
113228	84																													

*111819*  
*113228* *11/26/09* (3)

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Work Order ID: 54022



Parent Item: D407-559-113



Parent Item Name: Bearpaw, Large

Start Date: 11/26/2009

Required Date: 11/27/2009

Comments: IPP RevA: New issue DD 09.10.29 verified by:EC  
IPP RevB: ECN09-698p DD 09.11.03 verified by:EC  
as per revision K DD 09.11.24 verified by:EC

IPP RevC:

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21043-4		Purchased	No			160	Each	1,284.000	60.0000			
Nut												

✓ 9/11/26 (3)

Warehouse	Loc Qty	Loc Code
Location		
OFFSHORE		
FG	40	
104603	40	
Main Warehouse		
ST	1244	
112243	2	
112314	442	
112492	300	
113064	500	

m112314

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## 5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			20	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						2	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						2	D4010-041	BEARPAW ASSEMBLY
						8	D4011-1	CLAMP, SHORT
						2	D4011-3	CLAMP, LONG
						8	D4011-5	CLAMP, SHORT (OEM)
						10	D4012-1	CUSHION
						2	AN4C10A	BOLT
8	12	8	12	8	12		AN4-15A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
						4	AN4C13A	BOLT
						8	AN4C15A	BOLT
						8	AN4C17A	BOLT
16	24	16	24				AN960JD416	WASHER
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						20	MS21043-4	NUT
				8	12		NAS1149D0463J	WASHER
2		2					QS200M44S	CLAMP

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